



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D130-1046-111
Job Sheet 186519



009061

Part No: D130-1046-111

Job Qty: 1 pcs

Part Name: EC130/H130 Cable Cutter Upper Removable Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 12/21/18 *April 17*

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *Stk*

Description:

Note: D130-1046-111 REV.B IPP REV:A 18.04.26 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.22 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	12/21/18		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
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							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
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							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S169293

Part: D130 - 1046 - 111

Job No: 186519

Serial No/Batch: S169293

Revision: B

Inspector:

Exp Date:

Instructions: FAA STC SR02609SE 18/08/08, TC, LoA C-18

APR 03 2019

120	QC 4	1 pcs	12/21/18	0.00 0.00	Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
130	Packaging 3-1 - Stock - B4B	1 pcs	12/21/18	0.00 0.00	QC 4 - 9	DAS 46 9-89
					QC 4 - 46	APR 03 2019
					Packaging 3 - 1 - B4B	DAS 46 9-89
					Packaging 3 - 2 - B4B	APR 03 2019
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
135	DC - 1 - B4B	1 pcs	12/21/18	0.00 0.00	Packaging 3 - 36 - B4B	DAS 21 9-89
					DC - 1 - B4B	APR 03 2019
140	QC 21 - FG	1 pcs	12/21/18	0.00 0.00	DC - 2 - B4B	DAS 21 9-89
					QC 21 - FG - 21	APR 03 2019
					QC 21 - FG - 70	
Part Op 110 - (Pick Kit) Descriptions: 120 - (QC4- 100% Inspect kits for completeness) 130 - Identify and pack for shipping as per PPP D130-1046-111 Location: _____ 135 - (Document Control) Photocopy bluefile & type labels per PPP D130-1046-111 CHG001 140 - (QC21- Final Inspection - Work Order Release)						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5556-041	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5164534
D5605-1	Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5053108
D5631-1	Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5120000
LN9016-06K	Washer	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	5126527
LN9025-0610K	Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150409
LN9025-0620K	Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5142472
LN9037-06075	Bolt	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5124411
LN9338-06	Nut	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5139523
LN9386-06018A	Bolt, Titanium	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	5124412

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D5556-041	1	0	0
	D5605-1	2	12	0
	D5631-1	2	10	0
	LN9016-06K	6	47	0
	LN9025-0610K	2	0	0
	LN9025-0620K	2	50	0
	LN9037-06075	2	16	0
	LN9338-06	2	18	0
	LN9386-06018A	6	18	0

Part Specifications

Specifications could not be found.



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Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/21/18	0.00	0.00	Start Up Stores/Pkg-2		
110	Packaging	1 pcs		12/21/18	0.00	0.00	Packaging1-5		
120	QC	1 pcs		12/21/18	0.00	0.00	QC4		
130	Packaging	1 pcs		12/21/18	0.00	0.00	Packaging3-2		
135	DC	1 pcs		12/21/18	0.00	0.00	DC		
140	QC21-FG	1 Ea		12/21/18	0.00	0.00	QC21		

Part Op 130 - Identify and pack for shipping as per PPP D130-1046-111 Location: _____
Descriptions: 135 - Photocopy bluefile & type labels per PPP D130-1046-111 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5556-041	Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	
D5605-1	Spacer	2 Ea (2 ea)	90-Start up Operation	
D5631-1	Spacer	2 Ea (2 ea)	90-Start up Operation	
LN9016-06K	Washer	6 pcs (6 ea)	90-Start up Operation	
LN9025-0610K	Washer	2 pcs (2 ea)	90-Start up Operation	
LN9025-0620K	Washer	2 pcs (2 ea)	90-Start up Operation	
LN9037-06075	Bolt	2 pcs (2 ea)	90-Start up Operation	
LN9338-06	Nut	2 pcs (2 ea)	90-Start up Operation	
LN9386-06018A	Bolt, Titanium	6 pcs (6 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5556-041	1	1	0
	D5605-1	2	10	0
	D5631-1	2	12	0
	LN9016-06K	6	70	0
	LN9025-0610K	2	48	0
	LN9025-0620K	2	20	0
	LN9037-06075	2	18	0
	LN9338-06	2	0	0
	LN9386-06018A	6	24	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Part Specifications
Specifications could not be found.

Plex 11/16/18 11:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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ITEM	QTY -111	P/N	DESCRIPTION	MANUFACTURER	ALTERNATE PART
	X	D130-1046-111	REMOVABLE PROVISIONS, UPPER		
1	1	D5556-041	CUTTER ASSEMBLY, UPPER		
2	2	D5605-1	SPACER		
3	2	D5631-1	SPACER		
4	6	LN9016-06K	WASHER, BEVELLED (M6)		
5	2	LN9025-0610K	WASHER (M6)		
6	2	LN9025-0620K	WASHER (M6)		
7	2	LN9037-06075	HEX HEAD BOLT, (M6)		
8	2	LN9338-06	NUT (M6)		
9	6	LN9386-06018A	BOLT, TITANIUM (M6)		LN9386-06018
10	A/R	PR1422	SEALANT	PPG/DESOTO	P/S890 OR MIL-S-8802 COMPLIANT
11	A/R	NYCOTE 7-11BL	PROTECTIVE COATING	NYCOTE	
12	A/R	PENETROX A13	ELECTRICAL JOINT COMPOUND	BURNDY	

NOTES:

- 1) ALL DIMENSIONS IN MILLIMETERS.
- 2) NOT INCLUDED IN KIT. TO BE PROVIDED BY INSTALLER.
- 3) APPLY SEALANT (ITEM 10) TO CUTTER ASSEMBLY FAYING SURFACES UPON INSTALL.
- 4) WET INSTALL FASTENERS WITH SEALANT (ITEM 10).
- 5) DOME SEAL NUTS WITH SEALANT (ITEM 10).
- 6) FILLET SEAL AROUND CUTTER ASSEMBLY WITH SEALANT (ITEM 10).
- 7) FILLET SEAL AROUND FASTENER HEADS WITH SEALANT (ITEM 10).
- 8) REMOVE TOP FIBERGLASS LAYER TO BONDING STRIP BELOW. REMOVE NON-CONDUCTIVE COATING ON MATING SURFACE OF CUTTER ASSEMBLY, UPPER TO ϕ 18mm. ASSEMBLE WITH ELECTRICAL JOINT COMPOUND (ITEM 12).
- 9) CONTACT AREA TO BE CLEAN OF ALL NON-CONDUCTIVE COAT (ϕ 8mm).
- 10) AFTER ASSY, BARE METAL SURFACES TO BE PROTECTED WITH SEALANT (ITEM 10).
- 11) TRIM TIP FACE FLUSH WITH BOTTOM OF COUNTERBORE IN CUTTER ASSEMBLY, UPPER.
- 12) THIS VIEW FOR USE WITH REMOVAL INSTRUCTIONS, CHAPTER 25 OF ICA-D130-1046, OR WHEN INSTALLING FIXED PROVISIONS FOR LATER USE (WITHOUT THE CUTTER ASSEMBLY INSTALLED).
- 13) IF FIXED ROOF PROVISIONS ARE ALREADY INSTALLED, TRANSFER DRILL ϕ 8.8mm (2 PL) AND ϕ 6.2mm (6 PL) FROM ROOF INSERTS TO CUTTER ASSEMBLY (ITEM 1). OTHERWISE, DRILL CUTTER ASSEMBLY (ITEM 1) ϕ 8.8mm (2 PL) AND ϕ 6.2mm (6 PL) USING DIMENSIONS ON SHEET 2.

B	ADD NOTE 12 & DIMS ON SHEET 2. CUTTER ASSEMBLY HOLES NOW DRILLED ON INSTALL	CP	18.06.26
A	NEW ISSUE	AJS	18.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JMH	DART AEROSPACE USA, INC.	
DRAWN	CP	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	N/A	D130-1046-111	SHEET 1 OF 4
APPROVED	DSW	TITLE	SCALE
DE APPR.	CP	REMOVABLE PROVISIONS, UPPER	NTS
DATE	18.06.26	COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	